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D2935

Job Sheet 181209



Part No: D2935

Job Qty: 24 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP A 00.06.06 New Issue EC IPP Rev:B Now 6061-T6 06-06-23 JLM

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 90    | Start up Operation | 24 Ea  |            | 8/31/18  | 0.00      | 0.00    | Start Up Waterjet     |           | DE 18/08/18   |
| 100   | Waterjet           | 24 pcs |            | 8/31/18  | 0.00      | 0.63    | Waterjet1             |           | DE 18/08/18   |
| 120   | QC                 | 24 pcs |            | 8/31/18  | 0.00      | 0.00    | QC8                   |           | AUG 15 2018   |
| 130   | HandFinish         | 24 pcs |            | 8/31/18  | 0.00      | 0.27    | HandFinish1           |           | P.R. 18/08/18 |
| 140   | QC                 | 24 pcs |            | 8/31/18  | 0.00      | 0.00    | QC7-1                 |           | AUG 16 2018   |
| 150   | Packaging          | 24 pcs |            | 8/31/18  | 0.00      | 0.00    | Packaging3            |           | AUG 17 2018   |
| 160   | QC21-SA            | 24 Ea  |            | 8/31/18  | 0.00      | 0.00    | QC21                  |           |               |

Part Op  
Descriptions: 100 - 1-Cut as per Dwg D2935

DAS  
21  
9-89

AUG 20 2018

### Job BOM

| Part / Item  | Component Name     | Quantity             | Operation             | Container |
|--------------|--------------------|----------------------|-----------------------|-----------|
| M6061T6S.080 | 6061-T6 .080 Sheet | 1.2168 sf (.0507 ea) | 90-Start up Operation | 5099480   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M6061T6S.080   | 1        | 27        | 0         |

### Part Specifications

| Spec No | Description   | Target/Tolerance               | Limits         | Type     | Special Comments |
|---------|---------------|--------------------------------|----------------|----------|------------------|
| 1       | Saddle Spacer | 0.257Inches + 0.006<br>- 0.001 | 0.263<br>0.256 | Diameter |                  |
| 2       | Saddle Spacer | 3.910Inches ± 0.030            | 3.940<br>3.880 |          |                  |
| 3       | Saddle Spacer | 1.354Inches ± 0.010            | 1.364<br>1.344 |          |                  |
| 4       | Saddle Spacer | 0.250Inches ± 0.010            | 0.260<br>0.240 |          |                  |
| 5       | Saddle Spacer | 0.250Inches ± 0.030            | 0.280<br>0.220 | Radius   |                  |



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                     |                                                                                                                                                                                    |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|--|-----------------------|--|--|------------------------------------|-------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------------|----------------------------------|----------------------------------------|------------------------------------|----------------------------------------------|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                     | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspended/Unapproved <input type="checkbox"/> |                                      | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Cross tube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> |  |  |                       |  |  | Skid-tube <input type="checkbox"/> | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/>                                                                                                                                                 | Engineering <input type="checkbox"/> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Machining <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>                                                                                                                                         | Quality <input type="checkbox"/>     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Thermoforming <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>                                                                                                                                       | Other <input type="checkbox"/>       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Large Fab <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>                                                                                                                                                  |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Date : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                     | Step #: _____                                                                                                                                                                      |                                      | QTY Effective : _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |  |  | MRB (QSI042) Approval |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |
| Description Work Order Dev _____<br><br><div style="position: absolute; top: 10%; left: 10%; transform: rotate(-30deg); font-size: 0.8em;">           Dart Aerospace Ltd.<br/>           1270 Aberdeen Street<br/>           Hackensack, NJ 07641-1K7<br/>           CANADA<br/>           TEL.: 1 613 832-5200<br/>           Email: sales@dartaero.com<br/>           www.dartaero.com         </div> <div style="position: absolute; top: 40%; left: 30%; transform: rotate(-90deg); font-size: 0.8em;">           Date: 08/13/19         </div> <div style="position: absolute; top: 50%; left: 20%; transform: rotate(-90deg); font-size: 0.8em;"> <b>DART AEROSPACE</b><br/>           Container No: S101444<br/>           Part: D2935<br/>           Job No: 181209<br/>           Serial No/Batch: S101444<br/>           Revision:<br/>           Inspector:<br/>           Exp Date:<br/>           Instructions: Various STC's         </div> |                                     |                                                                                                                                                                                    |                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |  |  |                       |  |  |                                    |                                     |                                    |                                      |                                    |                                    |                                            |                                  |                                        |                                    |                                              |                                |                                    |                                    |                                   |  |